Work	Order	ID	5951	6
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Friday, June 04, 2010 3:04:52 PM



Page 1

Item ID: D4008-041 Accept Setup Start **Revision ID:** Stop Item Name: Fuel Filler Splash Guard Assembly Start Date: 6/4/2010 Start Oty: 1.00 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 6/10/2010 **Customer:** Reference: Start Run Date: 10-(~0) Tooling: Process Plan: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Qty Qty Stamp Code Number **Draw Nbr Revision Nbr** D4008 Α 100 0.00 1B10-6-10 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg (D4008-1) Dwg Rev: 6061.030 Prog Rev: 2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

OC

Memo

0.00

BW-6-10

Quality Control

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH		Ву	D	ate	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Ca	egory:	_ NCR: Ye	es No	DQA	\ :	Date:	
	Re	solution:	Disposit	on:	_ QA: N/C	Close	ed:		Date:	
NCR:			WORK OR	DER NON-CONFORM	ANCE (N	CR)			,	
DATE	STEP	Description of NC	In it in I		ion B	0	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Chief Eng Q	QC Inspector			
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		<u>.</u> '		,						

Work Order ID 59516

Friday, June 04, 2010 3:04:52 PM

Page 3

Item ID:

D4008-041

Accept

Setup Start

Stop



Revision ID:

Item Name:

Fuel Filler Splash Guard Assembly

Start Date:

6/4/2010

Start Oty: 1.00

Required Date: 6/10/2010

Reg'd Qty: 1.00



Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____ Date: ____

Tooling:

Date:

Run Start

Date:____

SPC (Y/N):

Tool # Plan

Code

Date:

Accept **Qty**

Reject Qty

Stop

Reject Insp. Number Stamp

Sequence ID/ **Work Center ID**

150



HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours**

0.00

0.00

160



Powdercoat Powder Coating Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

=) M 10/06/11

Memo

Memo

0.00

REMOVE PIN PRIOR TO POWDERCOATING

Start Time: 7: 15AM Oven Temperature: 320% Finish Time: 7; CLJAn

170



Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

(2) BK 10-6-U

W/O:			WO	RK ORDER CHANG	SES					
DATE	STEP	PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	jory:	_ NCR	: Yes	No DQ	A:	Date: _	
Resolution: Disposition: QA: N/C Clo					osed:		Date: _			
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE	(NCR)			
D.47F	0750	Description of NC	Description of NC Corrective Action Section		tion B		Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date			Chief Eng	QC Inspector

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Friday, June 04, 2010 3:04:55 PM

Work Order ID: 59516

Parent Item:

D4008-041

Parent Item Name:

Fuel Filler Splash Guard Assembly

Comments:

IPP rev A 10.01.27 New issue Prelim EC verified by:DD

10.05.03 as per ECN10-562 DD verified by:EC

IPP Rev:B

Start Qty: 1.00

Start Date: 6/4/2010

Required Date: 6/10/2010

Required Qty: 1.00

Component Item ID/ Item Name MS20470AD3-3

Replacement Mfg/ Item ID Purch Purchased

Bin Primary Item Location No

Last Location Route Seq ID 180

180

180

Unit of Oty on Measure Hand Each

8,543.000

Loc Code

326.0000

Qty per Kit Total Otv

Qty Date Issued Issued

Status

Rivet, Universal Head

Location ST319 1065

16941

Location

ST300

Loc Qty 8543 1435 7108

Nut

Screw

MS35206-S245

MS21042L08

Purchased

Purchased

Purchased

No

No

No

Loc Qty Loc Code 326 326

Each

Each

100.0000

Location Loc Qty Loc Code ST294 100

113898

114330

100 180 Each

434.0000



Loc Code

WASHER

NAS1149DN832J

Location Loc Qty ST298 434

114740

434

	-									
W/O:			W	ORK ORDER CHAN	GES					
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	egory:	NCF	R: Yes I	No DQ	A:	Date:	
	R	esolution:	Disposition	on:	QA:	N/C Clo	sed:		Date:	
NCR:				ER NON-CONFORM						
DATE	STEP	Description of NC	Description of NC Corrective Actio		ection B		Verific	cation	Approval	Approval
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Picklist Print

Friday, June 04, 2010 3:04:55 PM

Work Order ID: 59516

Parent Item:

D4008-041

Parent Item Name:

Fuel Filler Splash Guard Assembly

Comments:

IPP rev A 10.01.27 New issue Prelim EC verified by:DD

10.05.03 as per ECN10-562 DD verified by:EC

Start Date: 6/4/2010

Required Date: 6/10/2010

Page 3

Status

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

D3941

Replacement Mfg/ Item ID Purch Manufactured

Bin Primary Item Location No

Last Location Route Seq ID 180

IPP Rev:B

Unit of Qty on Measure Hand 65.0000

Loc Code

Qty per Kit Total 0.21

Otv 0.221053 Oty

Issued

Date Issued

Rubber Cushion

Location ST408

48512

Loc Qty 65

65

cut 1.25" long

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W/O:			W	ORK ORDER CHANGE	S			· · · · · · · · · · · · · · · · · · ·	
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date: _	
Resolution:			Dispositio	n:	QA: N/C C	losed:		Date: _	
NCR:		`	WORK ORD	ER NON-CONFORMA	NCE (NC	R)			
DATE	STEP	Description of NC	In tal at	Corrective Action Section B			ation Approval	Approval	
	Section A IIIIIa	Chief Eng	Action Description Chief Eng	Sign Date		Section C	Chief Eng Q0	QC Inspector	
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DART AEROSPACE LTD	Work Order:	59516
Description: FUEL FILLER SOIACH ASSEMBLY	Part Number:	4008 -041
Inspection Dwg: D4008-1 Rev: 14		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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ł	wing ension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Measured by:	G.	Audited by:	Prototype Approval:	N/A
Measured by.	14>		Deter	N/A
Date:	10-6-10	Date: 10/06/10	Date:	N/A

		Га	Revised by	Approved
Rev	Date	Change	KJ/JLM	
Α		New Issue	KOJULIVI	

3 2 QTY. -041 JOHN CAMERON AVIATION PART NUMBER ITEM NO. PART NUMBER DESCRIPTION SHOP COPY 1 Х D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY JCA-M47-2-26 RETURN TO **ENGINEERING** 2 D3941-1 RUBBER CUSHION **UNCONTROLLED COPY** 3 1 D4008-1 FUEL FILLER SPLASH GUARD CHANNEL 4 1 D4008-5 HINGE SUBJECT TO AMENDMENT 5 2 D4008-7 WASHER WITHOUT NOTICE 6 1 D4008-9 SPRING WORK ORDER 7 5 MS20470AD3-3 RIVET 2 MS35206S245 SCREW 9 6 NAS1149DN832J WASHER 10 2 MS21042L08 NUT 10> **SECTION A-A** SCALE: 2X D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY Α NEW ISSUE 10.02.05 REV. DESCRIPTION DATE 1) MATERIAL: N/A 1) IMATERIAL, INA 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4008 MFG, APPR 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4008-041" AND B/N USING FINE POINT PERMANENT INK MARKER SHEET 1 OF 10 APPROVED TITLE SCALE 8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER POWDER COAT SPLASH GUARD DE APPR.

NTS

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DATE

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10.02.05

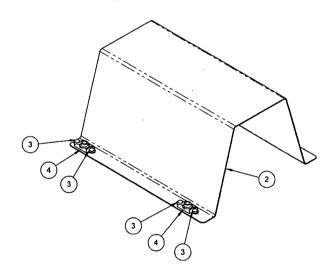
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9) MASK HINGE PIN AREA BEFORE POWDER COAT

10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER POWDER COAT

	-									
W/O:			WO	RK ORDER CHANG	ES				<u> </u>	
DATE	STEP	PROCEDURE CHANGE			Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:			WORK ORDE	R NON-CONFORMA	ANCE (N	CR)		-		
DATE	STEP	Description of NC	Description of NC Corrective Action			VAR			Approval	Approval
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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	Х	D4008-043	FUEL PUMP SPLASH GUARD ASSEMBLY	JCA-M47-2-29
2	1	D4008-3	FUEL PUMP SPLASH GUARD COVER	-
3	8	MS20426AD3-3	RIVET	
4	4	MS21059L08	NUT PLATE	



D4008-043 FUEL PUMP SPLASH GUARD ASSEMBLY



wlu 59516

NOTES;
1) MATERIAL:
2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4008-043" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.46 lbs

DESIGN	15	DART AEROSPA	CELTD
DRAWN	AL.	HAWKESBURY, ONTARI	
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	- 82	D4008	SHEET 2 OF 10
APPROVED	10,1	TITLE	SCALE
DE APPR.	-#-	SPLASH GUARD	NTS
DATE 10.0	2.05	COPYRIGHT © 2010 BY DART AT THIS DOCUMENT IS PROVATE AND CONFIDENTIAL AND IS SUPPLIED. NOT TO BE USED FOR ANY PURPOUS OR COMPETED OF COMMUNICA.	ON THE EXPRESS CONDITION THAT IT IS

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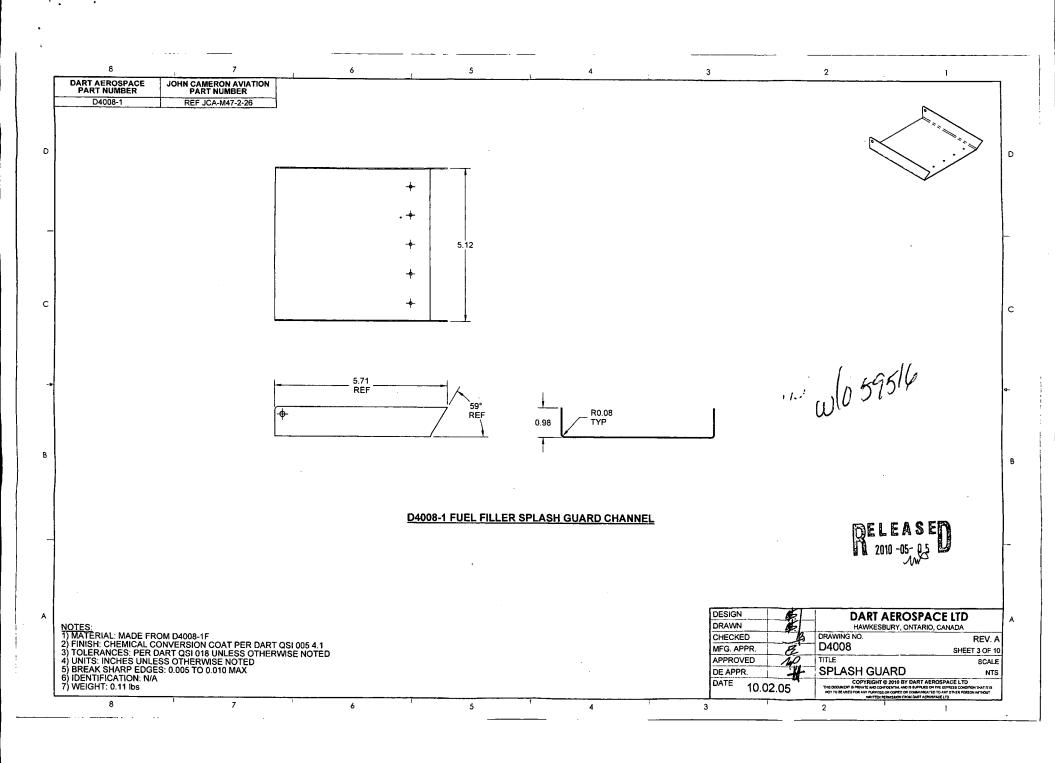
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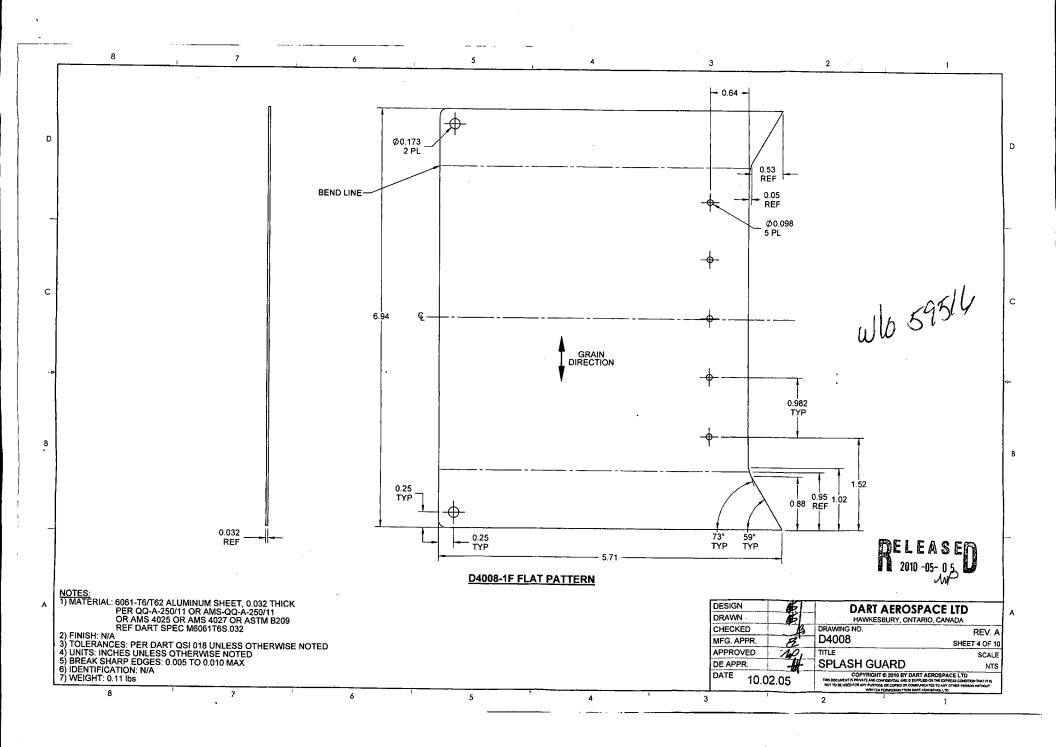
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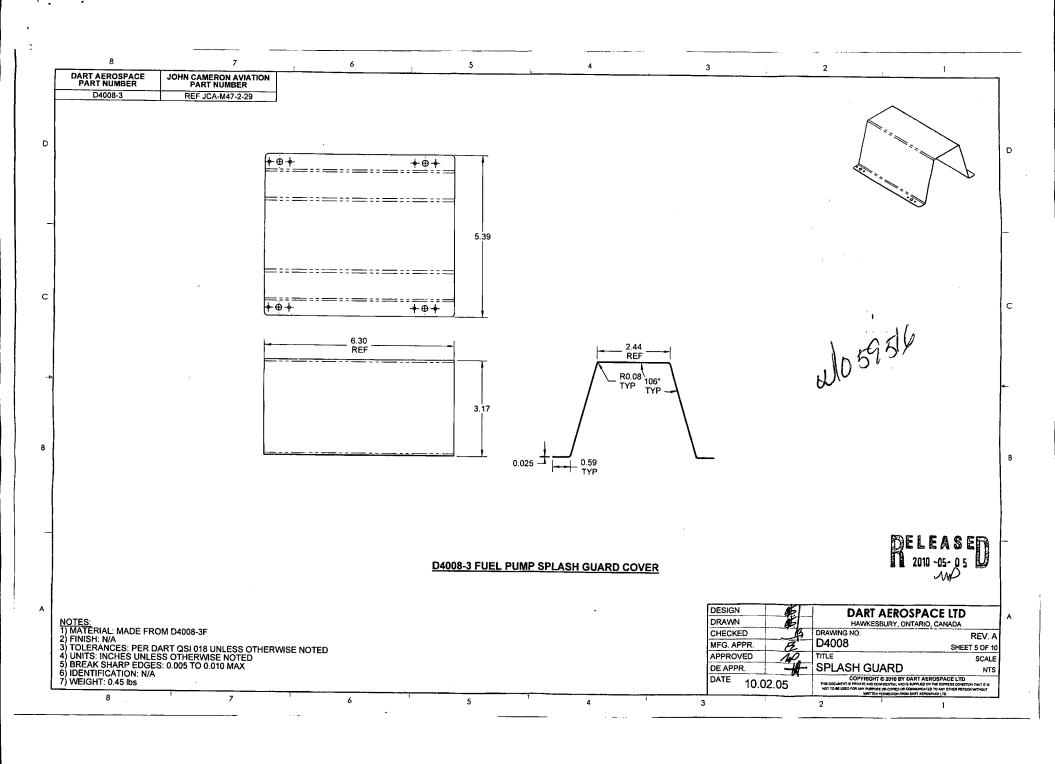
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DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC Corrective Action			ion B	Verific	Verification A		Approval
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Part No	•	PAR #:	Fault Cate	egory:	_ NCR: Ye	es No	DQ	A :	_ Date: _	
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DATE	STEP	Description of NC				Section B			Approval	Approval
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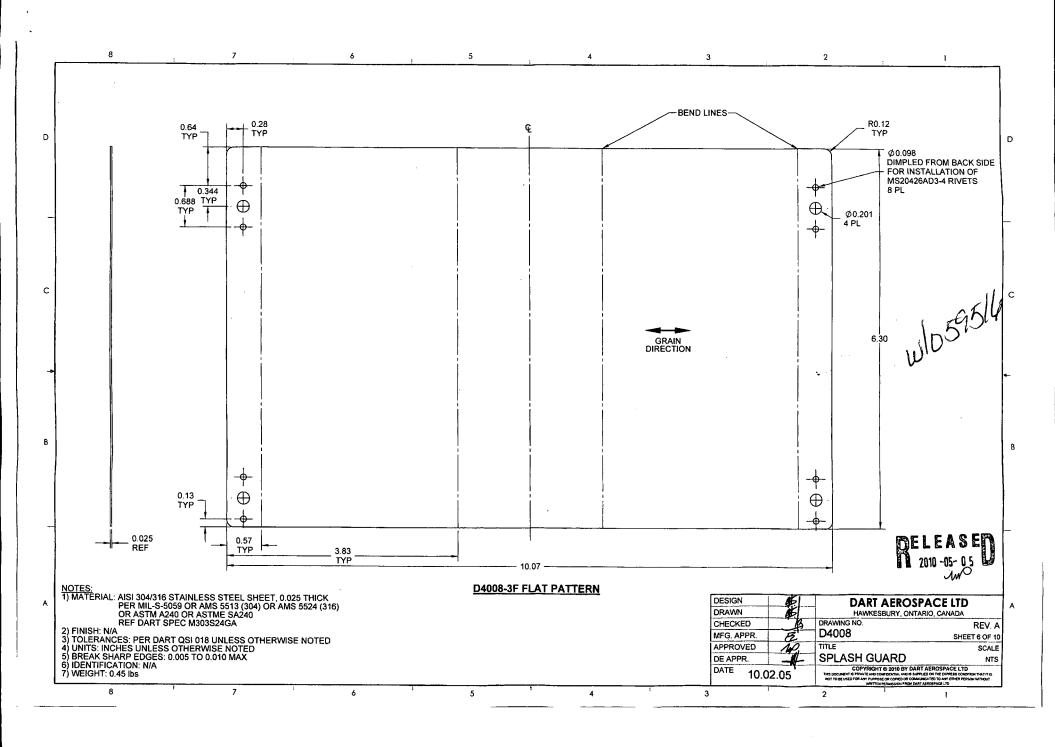


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DATE	STEP	Description of NC	Description of NC Corrective Action			Verifi	cation	Approval	Approval	
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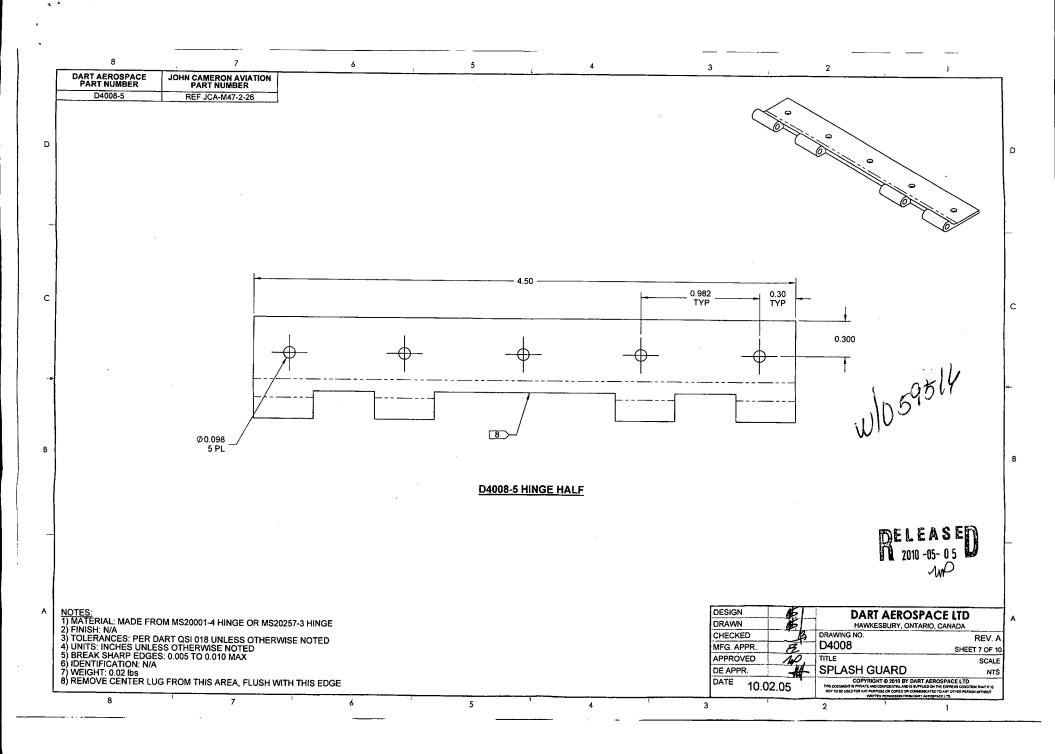


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DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

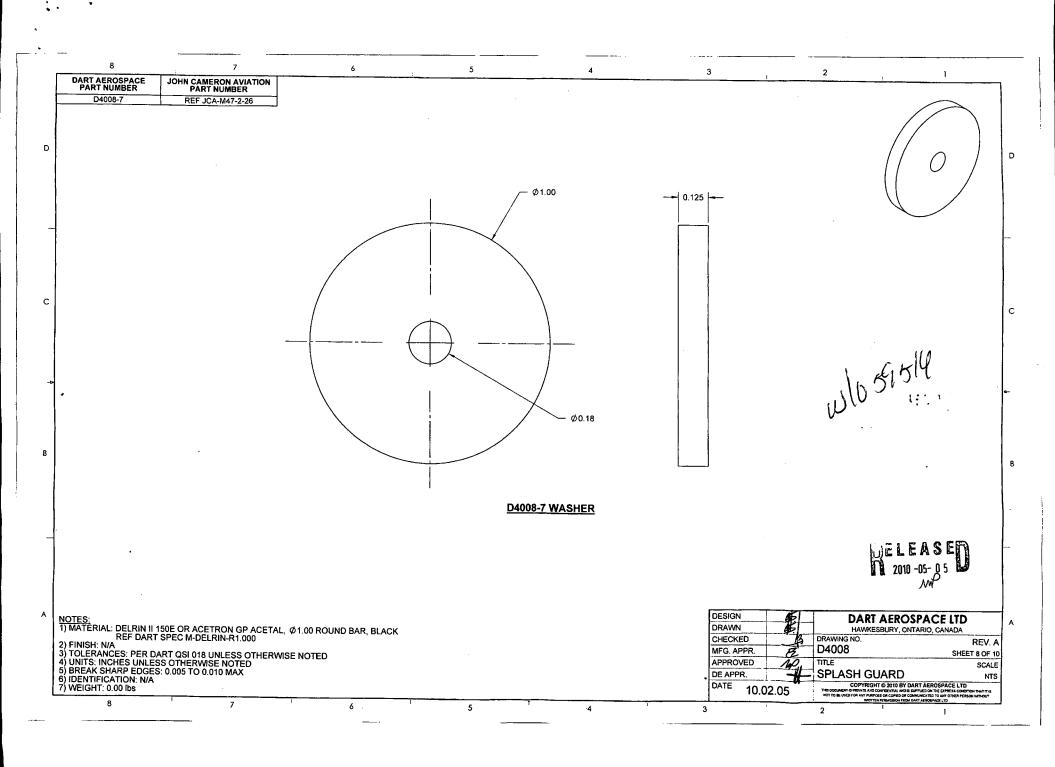
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NCR:			WORK ORDE	ER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action Section		ion B Sign		cation	Approval	Approval
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DATE	STEP	Description of NC			on B		Verific	ation	Approval	Approval
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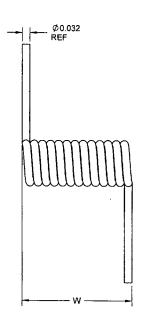
DART AEROSPACE PART NUMBER JOHN CAMERON AVIATION PART NUMBER D4008-9 REF JCA-M47-2-26

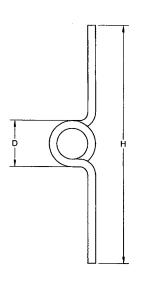
SPECIFICATION CONTROL DRAWING

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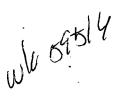


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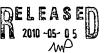


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DART P/N	SUPPLIER	SUPPLIER P/N	WIDTH "W"	HEIGHT "H"	DIAMETER "D"	MATERIAL
D4008-9	VICTORY SPRING	N/A	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE
D4008-9	BELL HELICOPTER	206-031-140-001	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE

D4008-X SPRING

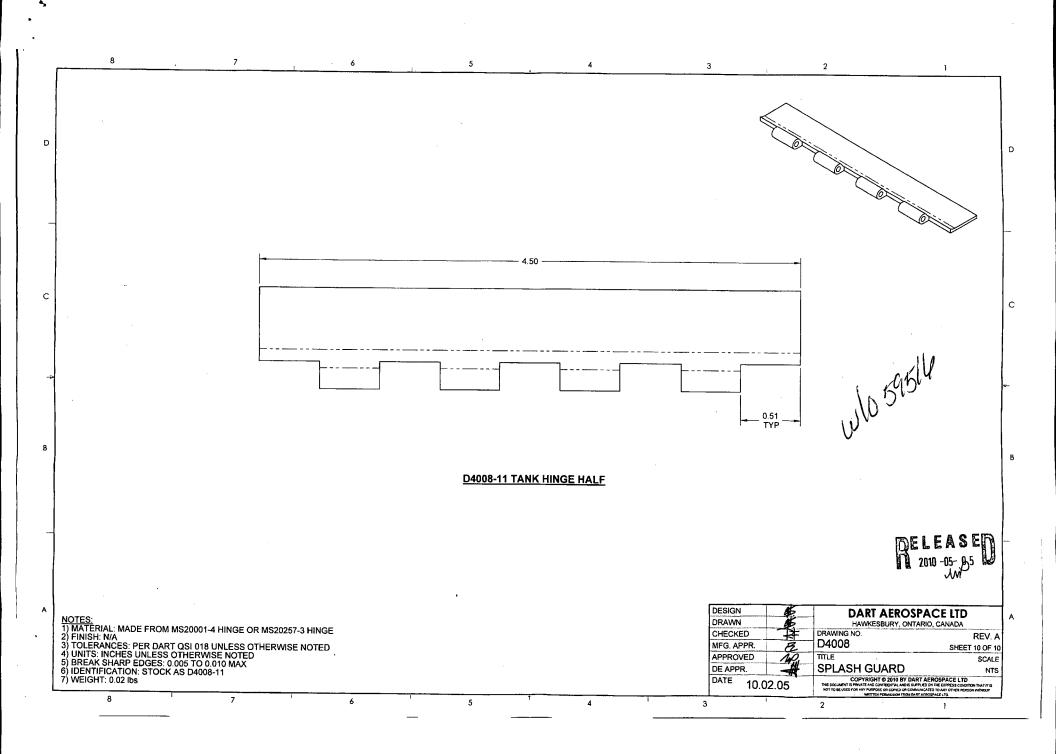


NOTES:	
1) MATERIAL:	T301 OR 304 STAINLESS STEEL SPRING WIRE Ø0.032 PER ASTM A313
I) WALL	1301 OK 304 STAINLESS STEEL SPRING WIRE QU.U32 PER ASTM A313

1) MATERIAL. TOT OR 304 STAINLESS STEEL SPRING WIRE \$\phi\cdot 0.032
2) FINISH: NIA
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.00 lbs

DESIGN	3 5	DART AEROSPA	CELTD
DRAWN	95	HAWKESBURY, ONTARIO	
CHECKED	B	DRAWING NO.	REV. A
MFG. APPR.	E	D4008	SHEET 9 OF 10
APPROVED	10.	TITLE	SCALE
DE APPR.	-#	SPLASH GUARD	NTS
DATE 10.0	2.05	COPYRIGHT @ 2010 BY DART AE THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED OF NOT TO BE USED FOR ANY PURPOSE OR COPED OR COMMUNICATION.	HITHE EXPRESS CONCITION THAT IT IS

W/O:			WC	ORK ORDER CHANG	GES	•				
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DATE	STEP	Description of NC						ation	Approval	Approval
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Dart Aerospace	Ltd
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W/O:			WC	ORK ORDER CHANG	GES				
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No: PAR #:		Fault Category: NC			CR: Yes No DQA: Date:				
Resolution:			Disposition	QA: N/C CI	A: N/C Closed: Date:				
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NCF	?)		···	
DATE	STEP	Description of NC	Corrective Action Section B			Verificati		Approval	Approval
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